Work Order ID 58934 Thursday, May 20, 2010 9:07:03 AM											
Revision ID:	D205-596-107 Crosstube Aft Extend	ded		Accept				Se	tup Start		<del></del>
Start Date: Required Date: Reference:		rt Qty: 1.00  'd Qty: 1.00			Cust Item Customer:					•	
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D205-596	Rev B										
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	BENI	DING MACHINE	- CROSSTUBES	0.00			(		<b>*</b>	MB 10-0	- 26
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CNC Alpha 100 Bellu	ici	Bend as pe	Dwg D28 using CNC	bender program							
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150 		QC5- Inspect part comp	leteness to step on W/O	0.00	petrol							

Memo

Quality Control

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NOTE: Date & initial all entries

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Quality Control

Memo



Page 4

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00 <b>11</b>		Crosstubes		0.00				m	17	1	_06_	a) (	i
Crosstubes Crosstubes		with 41058 v 2- Apply ma Batch: 114	gnobond 6398 as per dwg	D205-596-107 Magno EXP: الم	bond 6398						-00-		J
10 		QC5- Inspect part comple	eteness to step on W/O	0.00	10/66/03			_W					
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#### Work Order ID 58934

Thursday, May 20, 2010 9:07:03 AM



Page 5

Item ID:

D205-596-107

Accept

Setup Start

**Revision ID:** 

Item Name:

Crosstube Aft Extended

**Start Date:** 

5/20/2010

Start Qty: 1.00

Req'd Qty: 1.00



**Cust Item ID:** 

**Customer:** 

Draw

Number

Reference:

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Process Plan:

Date:

**Tooling:** 

Run

Accept

Qty

Start

Stop



QC:

Required Date: 6/7/2010

Date:

SPC (Y/N):

Date:

Draw

Rev.

Plan

Code

Date:

Stop

Reject

Number Stamp

Insp.

Sequence ID/ Work Center ID

220

Packaging

Packaging

**Operation** Description

Packaging

Set Up/ **Run Hours** 

0.00

0.00

Identify and pack for shipping as per PPP D205-596-107

Memo

Memo

PPP Rev:

230

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Reject

10/06/07 XIII

W/O:		WORK ORDER CHANGES											
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Thursday, May 20, 2	2010 9:07:08 AM								,			Page
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Parent Item: D2	205-596-107											6
Parent Item Name:	Crosstube Aft Exter	nded	1188(1	110 1E:0 11E:1 021	1 811)    8 2 2 811   14    6    6    6    1			S	tart Date: 5/20	/2010	Required Date:	6/7/2010
Comments:	IPP Rev:D □ 05.03.2 IPP Rev:E 08-01- IPP Rev F 08.04	-10 ECN 1075			ILM DD EC verified b	y: DD			Start Qty: 1.00		Required Qty:	
Component Item ID/ D2940-1 Support	Replacement	Mfg/ Manufactured	Bin No	Primary	Last	Route 200	Unit of Each	<b>Qty on</b> 45.0000	Qty per Kit	Qty	Date	Status
				<u>Loca</u> LG	45203 47748 52752	Loc	Oty 45 1 16 8	Loc Code	  		M 10 C	16 N
D6008-180  Crosstube Extrusion		Manufactured	No		57338	110	20 Each	11.0000	1 	18 /	0-05-2(	<i>o</i>
MS21920-28		Directions	No	<u>Locat</u> LG	46779	Loc	11 11	Loc Code		(X)	- -	
1 (8 8) E		Purchased	No			200	Each	55.0000	4			•

Clamp(per MIL-DTL-8783C)

**Location** Loc Oty Loc Code FG 105884 LG

50 112624 112863 113776 46

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#### **Picklist Print**

Thursday, May 20, 2010 9:07:08 AM

Page 2

Work Order ID: 58934

Parent Item:

D205-596-107

Parent Item Name:

Crosstube Aft Extended

Comments:

IPP Rev:D□05.03.21□Added bending procedure□KJ/JLM

IPP Rev:E 08-01-10

IPP Rev F 08.04.28

ECN 1075 Added bending & mat'l

EC verified by: DD

Start Date: 5/20/2010

Required Date: 6/7/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ D3595-063-530

Replacement Mfg/

Manufactured

Bin Primary No

Last

Route 200

Unit of Each

Qty on 96.0000 Qty per Kit Qty

Date

Status

**RUBBER CUSHION** 

Location FP

50030 51776 96 20 76

Loc Qty

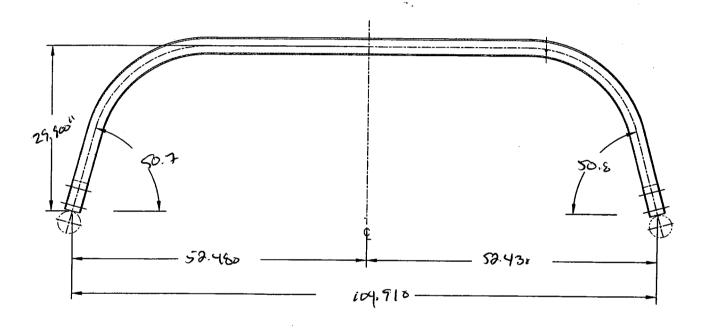
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DART AEROSPACE LTD	Work Order:	38934
Description: Crosstube High-High Aft	Part Number:	D205-596-107
Inspection Dwg: D205-596-107 Rev: B		Page 1 of 1

Required Dimension	Min	Max
Height	29.7	29.9
1/2 Span	52.4	52.6
Angle	49	52
Total Span	104.8	105.2



Comments									
* MARK	cat	Lin	<u>_@</u>	29.900"					

QC15 Inspection	δ.
Date	12/15/27

Rev	Date	Change	Revised by	Approved
Α	07.02.06	New Issue	KJ/JM	1
В	08.04.21	Dwg Rev updated	KJ/JM X	The
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W/O:		WORK ORDER CHANGES									
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#### PARTS LIST:

Qty	Part Number	Description					
X	X D205-596-107 CROSSTUBE ASSEMLBY, HI-HI AFT						
1	D6008-180	CROSSTUBE					
2	D2940-1	SUPPORT					
4	D3595-063-530	RUBBER CUSHION					
4	MS21920-28	CLAMP					
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)					

#### **GENERAL NOTES:**

1) MATERIAL: MANUFACTURE FROM D6008-180 FINISHED LENGTH =  $127.28 \pm 0.02$ 

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2 PAINT OUTSIDE PER DART 005 4.2

**TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED** 

UNITS: INCHES UNLESS OTHERWISE NOTED

**BREAK SHARP EDGES: N/A** 

IDENTIFICATION: SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS

7) WEIGHT: 50 lbs

PART IS SYMMETRIC ABOUT CENTERLINE

BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.

10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2940-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.

12) INSTALL MS21920-28 CLAMPS WITH D3595-063-530 RUBBER CUSHIONS TO SECURE D2940-1 SUPPORT ON THE TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.

NOTE: IT IS ACCEPTABLE TO SUBSTITUTE MS21920-28 CLAMPS WITH LONGER OR SHORTER MS21920-XX CLAMPS TO ACCOMODATE VARYING DIAMETERS. ENSURE THERE IS A MINIMUM OF 88-01. H. M 1.5 THREADS IN SAFETY ON THE NUTS.

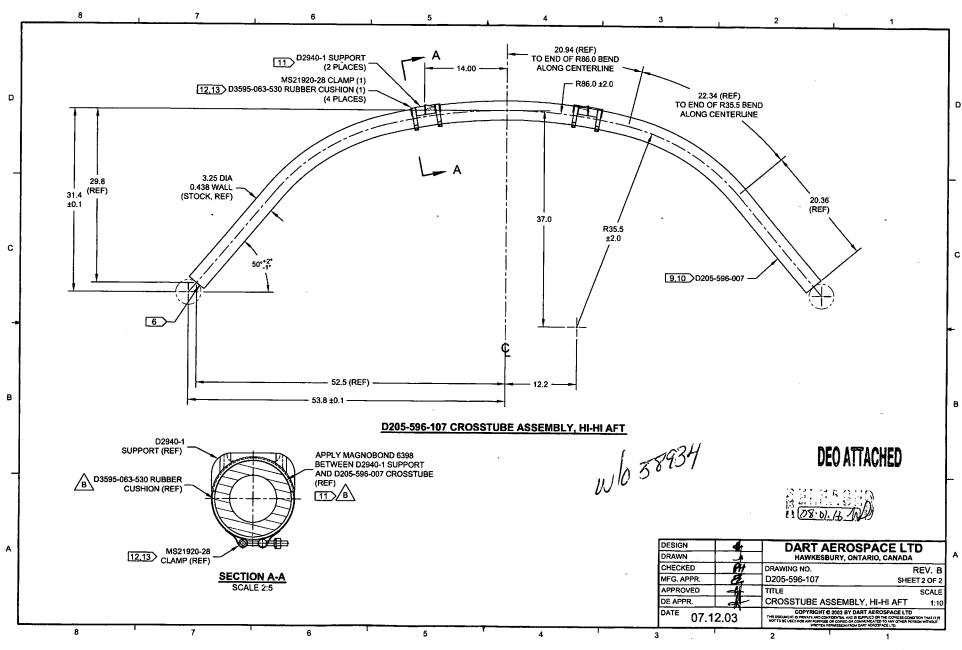
13) TORQUE CLAMPS 80 TO 100 IN-LB

DEO ATTACHED

В	1009 AE		NOBONDED; REMOVE D2856-600- IP; UPDATED NOTES; 30 CUSHION	МВ	07.12.03			
Α	NEW IS	SUE		DS	02.11.20			
REV.			DESCRIPTION	BY	DATE			
DESIGN			DART AEROSPA	ACE	LTD			
DRAWN		4	HAWKESBURY, ONTARIO, CANADA					
CHECKE	D	PH	DRAWING NO.	REV. E				
MFG. AP	PR.	Ex	D205-596-107		SHEET 1 OF 2			
APPROV	/ED	#	TITLE SCA					
DE APP	₹.		CROSSTUBE ASSEMBLY, F	1 <u> -H  A</u> [	FT NTS			
DATE	07.1	2.03	COPYRIGHT © 2002 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR MY PURPOSE OR COPIED OR COMMUNICATION TO MY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART RECORPACE LTD.					

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D205-596	-107	CROSSTU	BE			RING ORDER		96-107-B-1	SHEET 1		NTS
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DATE	09.05.	01	DATE	09.06.15	DATE	09.06.15	DATE	09/06/120	DATE OF	106/16	

#### CHANGE:

ADD THE FOLLOWING CROSSTUBE ASSEMBLY:

Part Number	Description
D205-596-107B	CROSSTUBE ASSEMBLY (214 HI-HI AFT)

THE D205-596-107B CROSSTUBE HAS THE SAME PARTS LIST AS THE D205-596-107 CROSSTUBE. HOWEVER, INSTALL THE SUPPORTS AS SHOWN IN FIGURE 1 OF THIS ENGINEERING ORDER. THE NEW KIT IS OTHERWISE ASSEMBLED PER THE D205-596-107 CROSSTUBE.



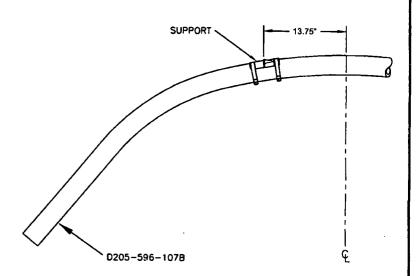


FIGURE 1 - SUPPORT INSTALLATION

w/o 58934

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Part No:		PAR #:	Fault Categ	jory:	NCR: Yes	No <b>DQA</b> : _	Date: _	
Resolution:			Disposition	_ QA: N/C Cld	osed:	Date: _	_ Date:	
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DATE	STEP De	Description of NC Section A	Corrective Action Section B			Verification	n Approval	Approval
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